

Work Order ID 144259

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144259

Page 1

Item ID: D350-591-117A Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Pre-Flight Step, Fits LH or RH
 Start Date: 4/11/2016 Start Qty: 1.00 ***1*** Cust Item ID:
 Required Date: 4/12/2016 Req'd Qty: 1.00 ***1*** Customer:
 Reference:

Approvals: Process Plan: SU 20160408 Run Start ***NR1***
 QC: Date: Tooling: Date: Stop ***NR2***
 SPC (Y/N): Date:

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
IIN-350-591	H								
100	Document Control	0.00							
100	DOCUMENT CONTROL								
DC	Memo	0.00							
Doc.Control -USB or Paperwork	Photocopy blue file and type labels per PPP D350-591-117A CHG003								
						DAS 28 9-89			APR 12 2016
110	Pick Kit	0.00							
110									
Packaging	Memo	0.00							
Packaging									
						DAS 6 9-89	DAS 27 9-89		APR 11 2016
120	QC4- 100% Inspect kits for completeness	0.00							
120									
QC	Memo	0.00							
Quality Control									
						DAS 28 9-89			APR 12 2016

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date : _____		Step #: _____		QTY Effective : _____			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval	

Root Cause				FAULT CATEGORY			
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐		
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐		
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐		
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐		
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐		
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐		
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐		
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐		
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐		
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐		
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____					
Misidentified ☐	Past Due ☐						

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Accept

Setup Start *NS1*

Stop *NS2*

Stop *NS2*

Cust Item ID:

Customer:

Reference:

Run Start *NR1*

Stop *NR2*

Operation Description

Set Up/ Run Hours

Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
---------	--------	-----------	------------	------------	---------------	-------------

130

0.00

130

Packaging

0.00

Packaging

Packaging

Memo

Identify and pack for shipping as per PPP D350-591-117A
Location: FG018

DAS
28
9-89

APR 12 2016

140

QC21- Final Inspection - Work Order Release

0.00

140

QC

Memo

0.00

Quality Control

MC5

APR 12 2016

APR 12 2016
MCS

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐																																																											
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Misidentified ☐	Past Due ☐																																																														

Picklist Print

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Work Order ID: 144259

144259

Parent Item: D350-591-117A

D350-591-117A

Parent Item Name: Pre-Flight Step, Fits LH or RH

Start Date: 4/11/2016

Required Date: 4/12/2016

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:A New Issue 06-06-28 JLM
 IPP Rev:B 08-09-09 under review as per PAR 08-031 DD
 IPP Rev C 09.02.06 ECN 09-513 EC verified by:DD IPP Rev:D
 as per ECN10-586 10.06.18 DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2171		Manufactured	No			110	Each	37.0000	2	2			
D2171									**				
Clamp													
	DAS 28 9-89												DAS 27 9-89
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST542				37					
				139964				37		2			
D2182B		Manufactured	No			110	f	465.1193	0.58	0.58			
D2182B									**				
Rubber Cushion - Black (\$Per Foot)													
	DAS 28 9-89												DAS 27 9-89
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST411				465.1193					
				130427				115.1193					
				135093				350					
(D2183B035) cut (2) at 3.5"													
D2274		Manufactured	No			110	Each	117.0000	4	4			
D2274									**				
Radius Block													
	DAS 28 9-89												DAS 27 9-89
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				FG				12					
				86855				12					
				ST012a				105					
				141052				105		4			

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Work Order ID: 144259

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Parent Item: D350-591-117A

D350-591-117A

Parent Item Name: Pre-Flight Step, Fits LH or RH

Start Date: 4/11/2016

Required Date: 4/12/2016

Start Qty: 1.00

Required Qty: 1.00

D2362-041 Manufactured No

110 Each 1.0000 1 1

D2362-041

350 Pre-Flite Step

DAS
28
9-89

Location

Loc Qty

Loc Code

ST537

1

129723

1

D3595-200-300 Manufactured No

110 Each 13.0000 1 1

D3595-200-300

Rubber Cushion 2.00" wide x 3.00" Long

DAS
28
9-89

Location

Loc Qty

Loc Code

FG

5

84209

5

ST416

8

142188

8

AN4-22A Purchased No

110 Each 139.0000 4 4

AN4-22A

Bolt

DAS
28
9-89

Location

Loc Qty

Loc Code

GA

50

116419

50

ST342

89

123348

89

DAS DAS
6 27
9-89 9-89

DAS DAS
6 27
9-89 9-89

APR 11 2016

DAS DAS
6 27
9-89 9-89

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Work Order ID: 144259

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Parent Item: D350-591-117A

D350-591-117A

Parent Item Name: Pre-Flight Step, Fits LH or RH

Start Date: 4/11/2016

Required Date: 4/12/2016

Start Qty: 1.00

Required Qty: 1.00

NAS1149D0463J

Purchased

No

110

Each

3,105.000

4

4

NAS1149D0463.J

WASHER

DAS

6

9-89

DAS

27

9-89

DAS
28
9-89

Location

Loc Qty

Loc Code

GA	136	
M129390	41	
M132035	95	
ST260a	1940	
M134573	1940	4
ST263	41	
M134039	41	
ST269	988	
M132317	100	
M132677	888	

MS21042L4

Purchased

No

110

Each

2,326.000

4

4

MS21042L 4

Locknut

DAS

27

9-89

DAS
28
9-89

Location

Loc Qty

Loc Code

FP001	37	
m133363	37	
GA	381	
m133769	381	
OVER007	1000	
m134606	1000	
ST303	811	
m134055	9	
m134502	802	4
ST305	97	
m130922	97	

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5.0 PARTS LIST

Qty -117A	Qty -119	Qty -133	Part Number	Description
X			D350-591-117A	<i>Heli-Access-Step</i> ™, Pre-Flight Step
	X		D350-591-119	<i>Heli-Access-Step</i> ™, Long Step - Low Skid
		X	D350-591-133	<i>Heli-Access-Step</i> ™, Aft Maintenance Step
	1		D2355	STEP ASSEMBLY (LOW-LONG)
		1	D2946-041	STEP ASSEMBLY (MAINTENANCE)
2	2		D2171	CLAMP
2	2		D2182B035	CUSHION
		4	D2230-1	MOUNTING LUG
		4	D2230-3	MOUNTING LUG
4	4		D2274	RADIUS BLOCK
1			D2362-041	SUPPORT BRACKET
	1		D2362-3	SUPPORT BRACKET
		1	D2945	MOUNTING PLATE
1	1		D3595-200-300	CUSHION
		8	D2732-030	CUSHION
	2		AN3-37A	BOLT
		2	AN4-7A	BOLT
		4	AN4-11A	BOLT
		8	AN4-16A	BOLT
	4		AN4-21A	BOLT
4	1		AN4-22A	BOLT
	4		NAS1149D0363J	WASHER (AN960JD10)
4	6	14	NAS1149D0463J	WASHER (AN960JD416)
	2		MS21042L3	NUT
4	5	14	MS21042L4	NUT

Qty -121	Qty -122	Qty -123	Qty -124	Part Number	Description
X				D350-591-121	<i>Heli-Access-Step</i> ™, Short Step - High Skid, LH
	X			D350-591-122	<i>Heli-Access-Step</i> ™, Short Step - High Skid, RH
		X		D350-591-123	<i>Heli-Access-Step</i> ™, Short Step - Low Skid, LH
			X	D350-591-124	<i>Heli-Access-Step</i> ™, Short Step - Low Skid, RH
1				D2351-041	STEP ASSEMBLY (HIGH-SHORT, LH)
	1			D2351-042	STEP ASSEMBLY (HIGH-SHORT, RH)
		1		D2356-041	STEP ASSEMBLY (LOW-SHORT, LH)
			1	D2356-042	STEP ASSEMBLY (LOW-SHORT, RH)
1	1	1	1	D2230-1	MOUNTING LUG
1	1	1	1	D2230-3	MOUNTING LUG
2	2	2	2	D2732-030	CUSHION
2	2	2	2	AN3-37A	BOLT
1	1	1	1	AN4-13A	BOLT
2	2	2	2	AN4-16A	BOLT
4	4	4	4	NAS1149D0363J	WASHER (AN960JD10)
6	6	6	6	NAS1149D0463J	WASHER (AN960JD416)
2	2	2	2	MS21042L3	NUT
3	3	3	3	MS21042L4	NUT